	Vork Order ID 51121 ugust 4, 2009 11:05:07 AM											Page
Revision ID:	D3066-1 B Spacer	er en		Accept				s s	etup	Start Stop	1 18811181 8	
Start Date: Required Date: Reference:	8/07/09 8/21/09	Start Qty: 40.00 Req'd Qty: 40.00	1100111	19	Cust Item I Customer:	D:						
Approvals:		n: WF	•			nte:		F	Run	Start Stop		
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Rejo Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr					-		41			
D3066	Rev	В										
Waterjet FLOW CNC Waterje	et	FLOW WATER JET Memo 1-Cut as per Deburr if nec	Dwg D3066 🗆 🗆 Ecessary	0.00 0.00 Dwg Rev:□Prog Rev:	<u>B</u> 🖂 2-			R	9-E	<u>4</u>	<u></u> .	<u> </u>
QC Quality Control		QC2- Inspect parts off ma	achine FAI/FAIB	0.00				HB (i-8-	4	· · · · · · · · · · · · · · · · · · ·	9
120 QC		QC8- Inspect parts - seco	and check	0.00	505/05/06	•		Control (FID)		£		

Quality Control

Memo

Dart	Aero	space	Ltd
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	-									
W/O:			WO	RK ORDER CHANG	GES					
DATE	STEP	PRO	OCEDURE CHAN	IGE	E	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									Ti de la companya de	
Part No	:	PAR #:	Fault Categ	ory:	_ NCR:	Yes N	lo DQ /	\ :	Date:	
	Res	solution:	Disposition	:	QA: N	/C Clo	sed:		Date:	
NCR:		,	WORK ORDE	R NON-CONFORM	ANCE (NCR)	Jan. 1.			
DATE	STEP	Description of NC	Corrective Action Section B			Verification			Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Section	on C	Chief Eng	QC Inspector
								•		
								:		
		•								

August 4, 2009 11:05:07 AM

Item ID:

D3066-1

Revision ID: В

Item Name: Spacer

Start Date:

8/07/09

Start Otv: 40.00



Accept

Setup Start

Stop

Required Date: 8/21/09

Rea'd Otv: 40.00



Cust Item ID: Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date:

Tooling: Date:

SPC (Y/N):

Date: Date:

Draw

Rev.

Plan

Code

Run

Start

Stop

Reject

Oty



Insp.

Stamp

Sequence ID/ Work Center ID

130

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours**

0.00

09-08-10

Accept

Oty

Reject

Number

140

OC

Quality Control

OC3- Inspect Part Finish

Memo

Memo

508/08/80

150

Packaging

Memo

Identify as per dwg & Stock Location:

0.00

0.00

Packaging

Dart Aerospace Ltd

	. ооршоо —											
W/O:		WORK ORDER CHANGES										
DATE	STEP	PR	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
							1					
							1					
Part No:		PAR #:	Fault Categ	jory:	NCR: Yes No DQA: Date:							
	Res	olution:	Disposition	:	_ QA: N/C C	losed:		Date: _				
NCR:		,	WORK ORDE	R NON-CONFORMA	NCE (NCI	7)						
DATE	STEP	Description of NC		on B	Verifi	cation	Approval	Approval				
DAIL	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	& Sect	ion C	Chief Eng	QC Inspector			
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Work Ord											Through a 1	Page 3	
Item ID: Revision ID: Item Name:	D3066-1 B Spacer			Accept				so	etup	Start Stop			
Start Date: Required Date Reference:	8/07/09	Start Qty: 40.00 Req'd Qty: 40.00		······	Cust Item I Customer:	D:							
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		nte:		R	un	Start Stop		#	
Sequence ID/ Work Center 160 QC Quality Control		Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Draw Number	Draw Rev.	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp 65:081() JA

Dart Aer	ospac	ce Ltd
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Dail AC	ospace	LIG									
W/O:			WC	RK ORDER CHANG	ES	···•) .		
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
1,12,1											
Part No:PAR #:			Fault Category: NCR: Yes No DQ								
			Disposition	1:	_ QA: N/C C	losed:		Date:			
NCR:			WORK ORDE	ER NON-CONFORMA	NCE (NCI	7)					
DATE	STEP	Description of NC		etion B Verifica			Approval	Approval			
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	& Secti		Chief Eng	QC Inspector		
							i				

Picklist Print

August 4, 2009 11:05:07 AM

Work Order ID: 51121

Parent Item:

D3066-1RevB

Parent Item Name: Spacer

Start Date: 8/07/09

Required Date: 8/21/09

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/	Replacen
Item Name	Item ID

ment Mfg/ Purch Bin Primary Item Location Last Location

Route Seq ID Unit of Measure Hand

Oty on Remaining Qty Oty To Pick Issued

Date Issued

Status

M6061T6S.080

Comments:

Purchased

No

100

sf

145.2290 3.9789

] [[] [] [] [] [] [] [] [] []

6061-T6 .080 Sheet

Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			
MAT	145.229		
107272	1.25		
110254	2.5		
110630	42.9353		<u> </u>
112040	34.5437		
112141	64		·
(ઇ) ૧૦૫			107904

Dart Aerospace Ltd

									
W/O:			WC	ORK ORDER CHANG	ES				y - e .
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No			Fault Category: NCR: Yes No DQA: Date:						
· ,.	Res	olution:	Dispositio	n:	_ QA: N/C CI	osed:		Date: _	
NCR:		·	WORK ORD	ER NON-CONFORM	ANCE (NCF	R)			
DATE	STEP	Description of NC		ion B	ation		Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti	on C	Chief Eng	QC Inspector
							•		



	DESIGN	4	DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
	CHECK	ED ⊘	APPROVED,,	DRAWING NO.	REV. B					
ļ		814	THE SHE	D3066	SHEET 1 OF 1					
	DATE			TITLE	SCALE					
	06.05.29		J5.29	SPACER	1:3					
_	Α	02	.09.11	NEW ISSUE						

06.05.29

ADD 6061-T6 MATERIAL

RELEASED

- 0.000 0.354 #51121 MF 09-08-04 2.600 4.850 - 7.100 - 9.350 \emptyset 0.128 (#30) (TYP 8 PLACES) 11.600 13.850 16.096 16.450 0.708 R0.354 (TYP) 0.354 -

D3066-1 SPACER

1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)

ÒR

5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK

(REF DART SPEC. M5052H32S.080)

2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1

3) BREAK ALL SHARP EDGES 0.005 TO 0.010 4) PART IS SYMMETRIC ABOUT CENTERLINE

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE LTD	Work Order: 5/12	
Description: Spacer	Part Number: D3066-1	
Inspection Dwg: D3066 Rev: B	Page 1 of	1_

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005 -0.000	.132	Я			
0.708	+/-0.010	706	\ x			
0.354	+/0.010	353	×			
0.354	+/0.010	.354	×			
2.250 (Pitch)	+/-0.005	156.6	79			
16.450	+/0.010	16.450				
0.080	+/-0.010	1076	*			
			<u> </u>			
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		•				
		.				
-						

Measured by:	Audited by:	5	Prototype Approval:	N/A
Date: 9-8-4	Date:	070866	Date:	N/A

Rev	Date	Change		Revised by	Approved
Α	03.09.22	New Issue	P/O D3065-041	KJ/RF	1
В	06.06.23	Dwg Rev. change	d	KJ/JLM ♂	- ////